

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026022**Date Inspected:** 07-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

| | | | | | | | |
|------------------------------------|------------|---------------------|--------------------|----------------------------------|------------|-----------|------------|
| CWI Name: | N/A | CWI Present: | Yes | No | | | |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No | N/A |
| | | | | Delayed / Cancelled: | Yes | No | N/A |
| Bridge No: | 34-0006 | Component: | OBG Trial Assembly | | | | |

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Lift 13 East (Longitudinal Diaphragm Triangular Plates)

This QA Inspector witnessed the final bolt tension verification for triangular plates connecting Longitudinal Diaphragm to Floor Beam between Panel Points (PP) 117.5 to PP 120 for Segment 13AE. The QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00747 dated August 07, 2011.

The bolt sizes used were M22 x 80 RC Lot # DHGM220140 and the final torque value established was 380 N-m.

The bolt sizes used were M22 x 90 RC Lot # DHGM220141 and the final torque value established was 353 N-m.

The Manual Torque wrench used was Serial No. XO2-777.

Lift 13 East (Inclined Plate on Diaphragm)

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector witnessed the final bolt tension verification for inclined plate on diaphragm from Panel Points (PP) 120 to PP 124.5 for Segment 13AE, 13BE and 13CE. The QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00747 dated August 07, 2011.

The bolt sizes used were M22 x 55 RC Lot # DHGM220011 and the final torque value established was 457 N-m.

The bolt sizes used were M22 x 65 RC Lot # DHGM220128 and the final torque value established was 357 N-m.

The Manual Torque wrench used was Serial No. XO2-777.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

| | | |
|----------------------|----------------|-----------------------------|
| Inspected By: | Math,Manjunath | Quality Assurance Inspector |
| Reviewed By: | Miller,Mark | QA Reviewer |
